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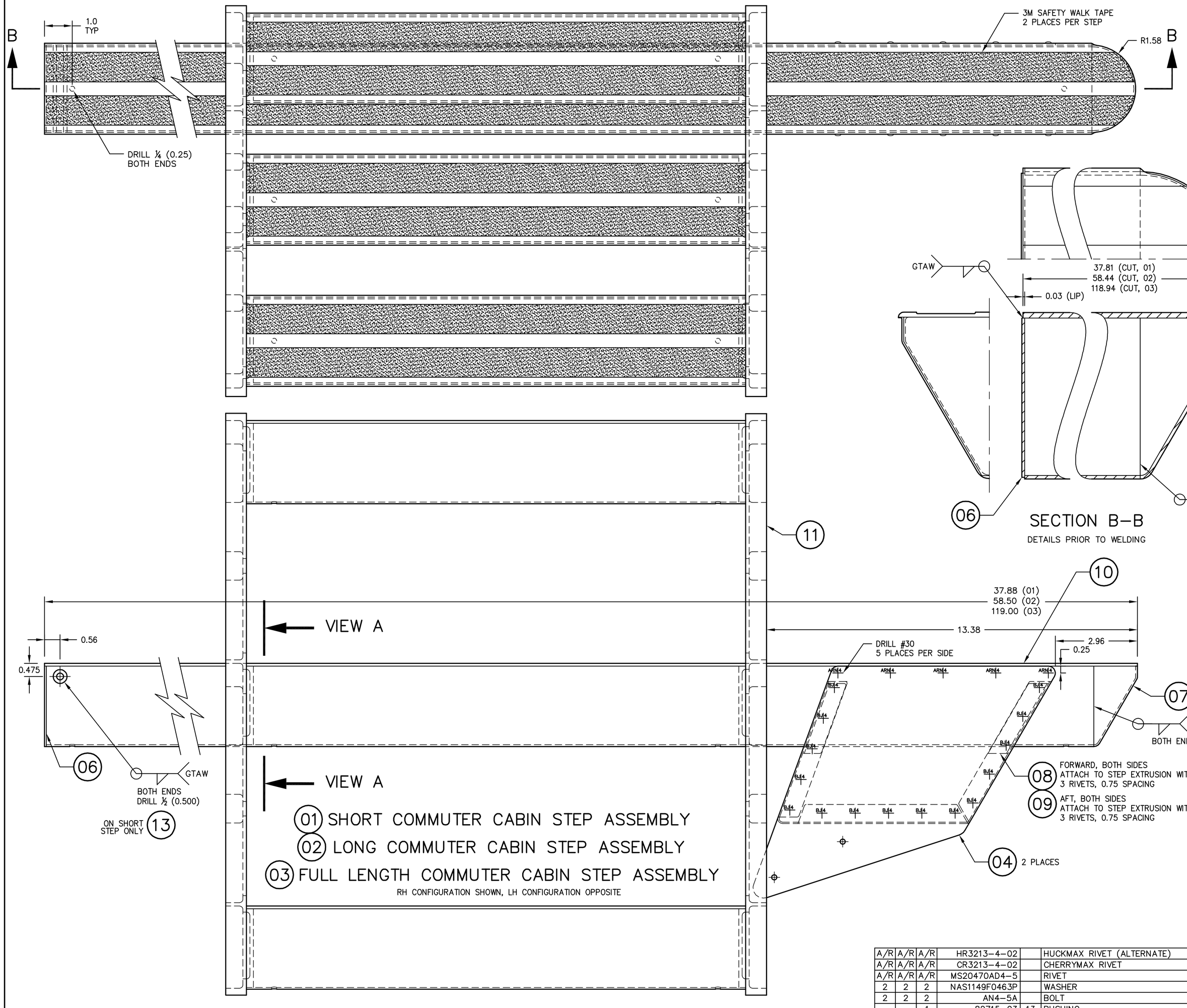
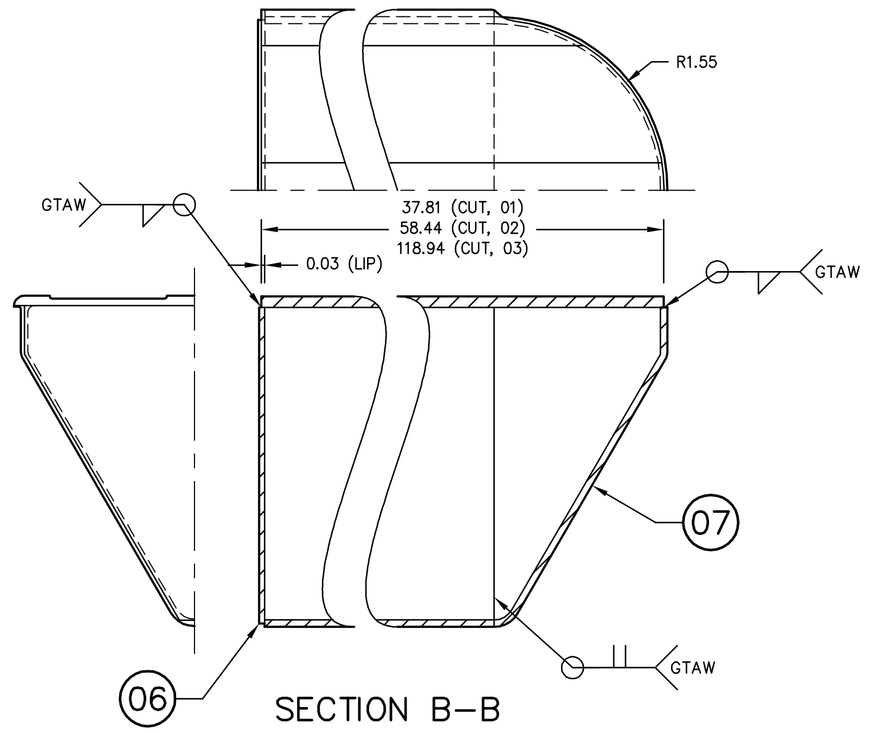
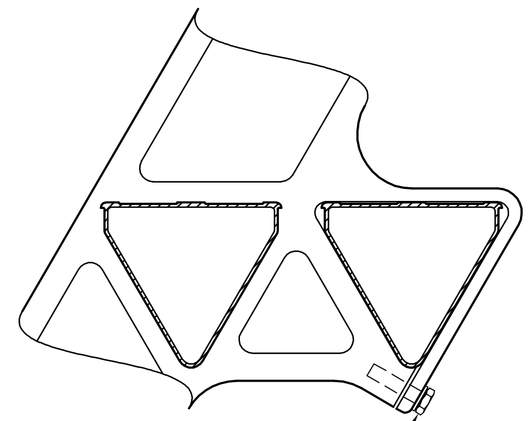
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGE LENGTH OF SHORT CONFIGURATION (ITEM 3)	BJC	29/11/2012
2	TITLE BLOCK UPDATED; HARDWARE UPDATED; ALTERNATE FINISH; END DETAILS	BJC	29/07/2014

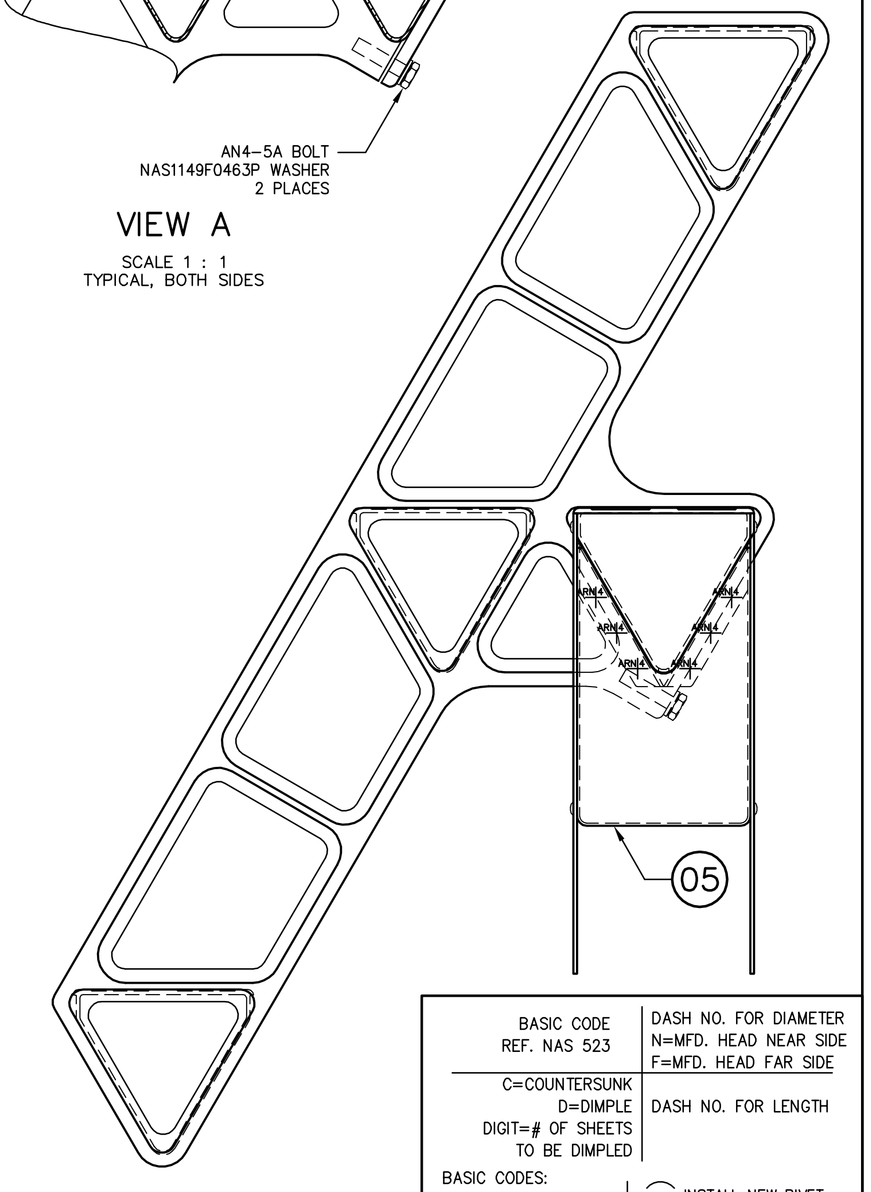




SECTION B–B
DETAILS PRIOR TO WELDING



VIEW A
SCALE 1 : 1
TYPICAL, BOTH SIDES



A/R	A/R	A/R	HR3213–4–02		HUCKMAX RIVET (ALTERNATE)
A/R	A/R	A/R	CR3213–4–02		CHERRYMAX RIVET
A/R	A/R	A/R	MS20470AD4–5		RIVET
2	2	2	NAS1149F0463P		WASHER
2	2	2	AN4–5A		BOLT
		1	82715–03	13	BUSHING
A/R	A/R	A/R	82718–12	12	3M SAFETY–WALK TAPE (1" WIDE)
1	1	1	82760–01	11	COMMUTER STEP ASSEMBLY
A/R	A/R	A/R	78240	10	STEP EXTRUSION
2	2	2	82736–03	09	ANGLE
2	2	2	82734–05	08	ANGLE
1	1	1	82734–04	07	CONE
1	1	1	82734–03	06	CAP
1	1	1	82736–02	05	CHANNEL
2	2	2	82736–01	04	SHEET
			82718–03–02	03	FULL LENGTH COMMUTER CABIN STEP ASS'Y (LH)
			82718–03–01	03	FULL LENGTH COMMUTER CABIN STEP ASS'Y (RH)
			82718–02–02	02	LONG COMMUTER CABIN STEP ASSEMBLY (LH)
			82718–02–01	02	LONG COMMUTER CABIN STEP ASSEMBLY (RH)
			82718–01–02	01	SHORT COMMUTER CABIN STEP ASSEMBLY (LH)
			82718–01–01	01	SHORT COMMUTER CABIN STEP ASSEMBLY (RH)
02	02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	QTY	LIST OF MATERIALS		

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY. APPLY SAFETY–WALK TAPE AFTER POWDER COATING. SLIDE COMMUTER STEP ASSEMBLY IN PLACE AFTER APPLYING SAFETY WALK TAPE.

   ALTERNATE: THOROUGHLY DEGREASE, ALODINE, AND PRIME ALL ALUMINUM PARTS PRIOR TO ASSEMBLY. PAINT AFTER ASSEMBLY, BEFORE INSTALLING COMMUTER SECTION.
4. TORQUE AN4 BOLTS TO 30–40 IN–LBS (3.4–4.5 N–m).

BASIC CODE REF. NAS 523	DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE
C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH

BASIC CODES:
BJ = MS20470AD
BB = MS20426AD
ARN = CR3213
ARM = CR3212

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS	DATE
DRAWN: JEFF CLARKE	23 JULY 2010
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2376 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
FIXED CABIN STEP
COMMUTER CABIN STEP ASSEMBLY

SCALE 1 : 2	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	82718	2